

Replacement

- 1 Expose side member in deformed range.
- 2 Separate damaged portion of side member outer shell (1) from inner shell (2) (Fig. 1).

Note: Remove weld flanges of side member outer shell by drilling holes of approx. 8 mm dia. and cut-out damaged part with a hand saw or a cutting-off grinder.

- 3 Grind off remaining sheet metal and straighten flanges (3) (Fig. 1).

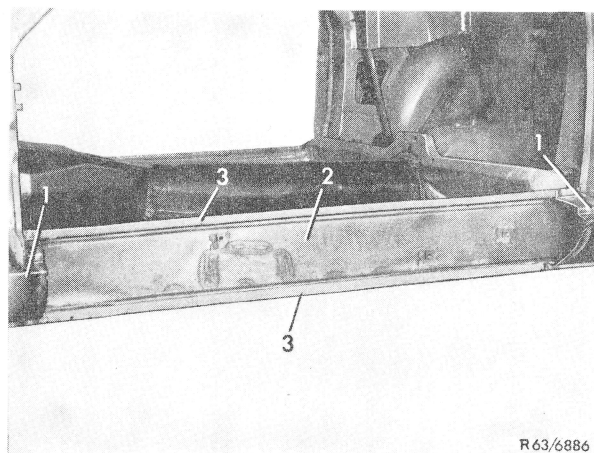


Figure 1

- | | |
|---------------------------|-----------|
| 1 Side member outer shell | 3 Flanges |
| 2 Side member inner shell | |

- 4 Cut new outer shell to size and fit.
- 5 Drill 8 mm dia. holes in both flanges (3) of outer shell (1) 50 mm apart (Fig. 2).

Note: The holes are required to connect the outer shell to the inner shell by plug welding.

- 6 Coat inside of outer shell and inner shell with zinc dust paint, Part No. 000 986 34 42.

- 7 Attach new outer shell (1) to inner shell with hand vices (4), align and tackweld (Fig. 2).

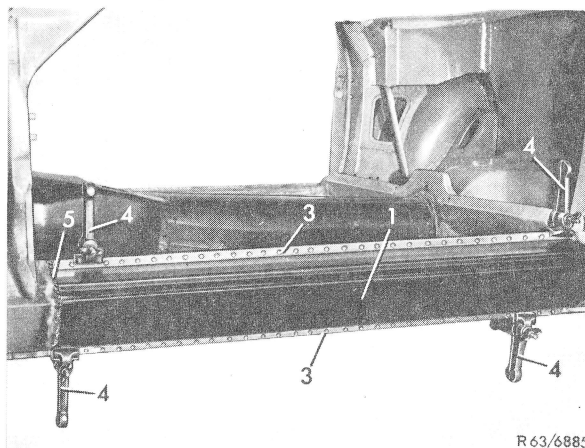


Figure 2

- | | |
|---------------------------|--------------|
| 1 Side member outer shell | 4 Hand vices |
| 3 Flanges | 5 Joints |

- 8 Connect outer shell to inner shell by plug-welding.

- 9 Weld joints (5).

- 10 Grind welding seams, braze and clean.

- 11 Paint repaired area and provide with permanent underfloor protection, also refinish cavity preservation.

- 12 Reinstall disassembled parts.